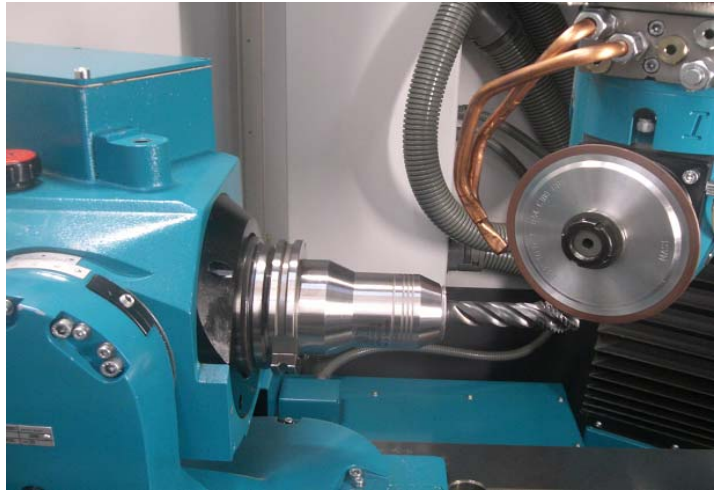




Tap M24

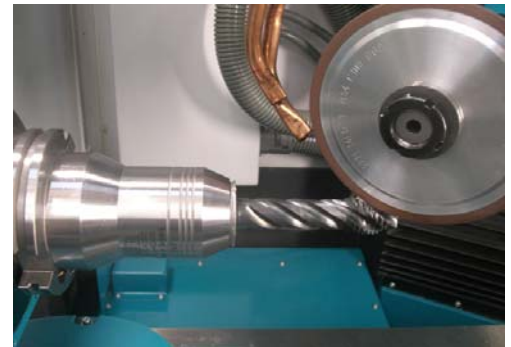
A10-010

Rake angle 8°, compromise for cutting speeds between 7 m/min (Inox 900) and 15 m/min (Steel 900).



1. Cycletime for Resharpenering

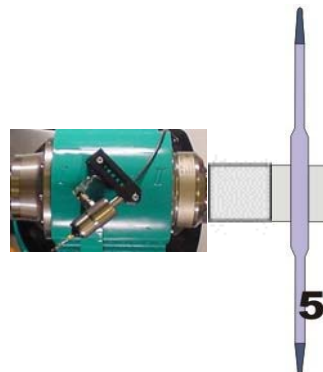
| Tool specifications | | | | | |
|--|--|--|--|--|--|
| Diameter 24 mm, Z 4, Length of cutting edge 40 mm, Helix angle 45° | | | | | |
| Material HSS | | | | | |
| Operations |  |  | | | |
| Feed [mm/Min] | 1 | 140 | | | |
| Power [kW] | | 2 | | | |
| Cutting feed [m/s] | | 18 | | | |
| Used wheels | | 5 | | | |
| Grinding time [s] | 60 | 117 | | | |
| Total cycle time | 2 Min 56 | | | | |



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|----------------|
| 5 | 14F1 Ø150 B126 |
|---|----------------|



3. Machine and Software Requirements

Machines: 2 axes CNC grinders : ARIES ENP 2
 Control: Fanuc 35i
 Coolant: Synthetic Oil, pressure 3 bar
 Software: Menu guided macro executer

responsible engineer: KCM, 16.09.09

www.schneeberger.ch

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